

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004911**Date Inspected:** 09-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	PQR mechanical testing and deck panel				

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

This QA was directed by Caltrans QA task leader Mr. Albert Carreon to accompany American Bridge Fluor (ABF) representative identified as Mr. Craig Knopps to verify and witness ZPMC QC personnel perform mechanical testing for Procedure Qualification Record (PQR)'s identified as HP2008110, HP2008111 and HP2008112. QA noted that the charpy V notch tests for PQR HP2008110 failed to meet the acceptance criteria of AWS D1.5 2002. QA also noted that ZPMC did not perform Charpy's for PQR's HP2008111 and HP2008112 stating that due to the fact that the joints did not conform to figures 2.4 or 2.5 Charpy's are not required according to figure 5.3 AWS D1.5 2002. All bend and tension tests performed for all three PQR's appeared to meet the requirements of D1.5 2002. Copies of the test results were submitted to Caltrans QA. This QA issued a copy of the results to Caltrans QA Task leader Robert Cuellar for review.

Out side OBG assembly

QA Performed Gate to Gate (G2G) preliminary Ultrasonic Testing (UT) at the tacked areas on u-rib to deck plate PJP welds for the following deck panel:

DP-563-001:

Weld# 1 – 20 tacks UT'ed – 2 indications

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Weld# 2 – 20 tacks UT'ed – 6 indications

Weld# 3 – 20 tacks UT'ed – 4 indications

Weld# 4 – 20 tacks UT'ed – 3 indications

Weld# 5 – 20 tacks UT'ed – 5 indications

This QA along with Caltrans QA Mr. Arron Wintrich completed the G2G UT on this deck panel and recorded the Y locations on the tack weld assessment sheet and submitted a copy to Caltrans QA task leader Mr. Mark Wright to be entered on the Caltrans server.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
